

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS  <b>FOREIGN PLANT REVIEW FORM</b>		REVIEW DATE 2/18/2002	ESTABLISHMENT NO. AND NAME 34 - Århus Slagterhus A/S		CITY Århus	COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. H. Petersen, Palle Andersen, O. Moeller		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input checked="" type="checkbox"/> Unacceptable		
CODES (Give an appropriate code for each review item listed below) A = Acceptable    M = Marginally Acceptable    U = Unacceptable    N = Not Reviewed    O = Does not apply						
1. CONTAMINATION CONTROL		Cross contamination prevention		28 M	Formulations	55 O
(a) BASIC ESTABLISHMENT FACILITIES		Equipment Sanitizing		29 A	Packaging materials	56 O
Water potability records	01 A	Product handling and storage		30 A	Laboratory confirmation	57 O
Chlorination procedures	02 O	Product reconditioning		31 A	Label approvals	58 O
Back siphonage prevention	03 A	Product transportation		32 A	Special label claims	59 O
Hand washing facilities	04 U	(d) ESTABLISHMENT SANITATION PROGRAM			Inspector monitoring	60 O
Sanitizers	05 A	Effective maintenance program		33 M	Processing schedules	61 O
Establishments separation	06 A	Preoperational sanitation		34 A	Processing equipment	62 O
Pest --no evidence	07 A	Operational sanitation		35 M	Processing records	63 O
Pest control program	08 A	Waste disposal		36 A	Empty can inspection	64 O
Pest control monitoring	09 A	2. DISEASE CONTROL			Filling procedures	65 O
Temperature control	10 A	Animal identification		37 A	Container closure exam	66 O
Lighting	11 U	Antemortem inspec. procedures		38 A	Interim container handling	67 O
Operations work space	12 A	Antemortem dispositions		39 A	Post-processing handling	68 O
Inspector work space	13 A	Humane Slaughter		40 A	Incubation procedures	69 O
Ventilation	14 A	Postmortem inspec. procedures		41 M	Process. defect actions -- plant	70 O
Facilities approval	15 A	Postmortem dispositions		42 A	Processing control -- inspection	71 O
Equipment approval	16 A	Condemned product control		43 A	5. COMPLIANCE/ECON. FRAUD CONTROL	
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control		44 A	Export product identification	72 A
Over-product ceilings	17 A	Returned and rework product		45 A	Inspector verification	73 A
Over-product equipment	18 A	3. RESIDUE CONTROL			Export certificates	74 A
Product contact equipment	19 A	Residue program compliance		46 A	Single standard	75 A
Other product areas (inside)	20 A	Sampling procedures		47 A	Inspection supervision	76 M
Dry storage areas	21 A	Residue reporting procedures		48 A	Control of security items	77 A
Antemortem facilities	22 A	Approval of chemicals, etc.		49 A	Shipment security	78 A
Welfare facilities	23 A	Storage and use of chemicals		50 A	Species verification	79 O
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL			"Equal to" status	80 U
(c) PRODUCT PROTECTION & HANDLING		Pre-boning trim		51 O	Imports	81 O
Personal dress and habits	25 A	Boneless meat reinspection		52 O	SSOPs	82 A
Personal hygiene practices	26 U	Ingredients identification		53 O	HACCP/PR	83 U
Sanitary dressing procedures	27 U	Control of restricted ingredients		54 O		

FOREIGN PLANT REVIEW FORM (reverse)	REVIEW DATE 2/18/2002	ESTABLISHMENT NO. AND NAME 34 - Århus Slagterhus A/S	CITY Århus COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. H. Petersen, Palle Andersen, O. Moeller		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input checked="" type="checkbox"/> Unacceptable

## COMMENTS:

04 Neither of the two leggers on the slaughter line had a hand soap dispenser. The DVFA officials ordered prompt correction.

11 Lighting was inadequate at all inspection stations. The European Commission regulations require 540 Lux, or 49 foot-candles (fc) of light. The Auditor measured 35 fc at the head lymph nodes, 30 fc on beef necks, 20 fc on the viscera tray, and only 10 fc in abdominal cavities. The DVFA officials ordered prompt correction.

26 (A) The establishment worker examining beef quarters for visible contamination prior to shipping did not wash his hands after handling contaminated trimmings, thus further contaminating product. Corrective actions were attempted twice by the establishment management, and were ineffective both times. (B) The establishment worker responsible for trimming visible contamination on the slaughter line did not wash his hands after handling contaminated trimmings, thus further contaminating product. The DVFA officials ordered immediate corrective action.

27 Several butchers on the slaughter line were observed to fail to sterilize their knives after making opening skin cuts before continuing their skinning operations. The DVFA officials ordered corrective actions, but they were not effective immediately.

27/83 The written HACCP plan called for the designated carcass trimmer, whose position on the slaughter line was immediately after the carcass inspector, to document the incidence of fecal contamination. This was not being done. The establishment was relying on the DVFA final carcass inspector to document electronically the fecal contamination he observed, and when the more than four out of ten consecutive carcasses were noted with fecal contamination, an alarm on the foreman's telephone would be activated. The last documented incidence of the action level of more than 4 out of 10 carcasses with visible fecal contamination was October 13, 1999. The Auditor observed three out of ten quarters ready for shipping that had visible fecal contamination. These quarters had passed not only inspection on the slaughter line, but also pre-shipping inspection. Furthermore, visible fecal contamination and/or pieces of hide were observed on approximately 30% of beef halves on the first rail examined in the coolers, and also on two tails that were ready for packing. The DVFA officials ordered re-inspection of all the carcasses and the tails.

28 Large plastic containers for edible product were routinely placed directly on the floor. The DVFA officials agreed to require corrective actions. Also, beef tails routinely contacted equipment at the bung-dropping station. No corrective actions were taken.

33 Several cracked or torn stainless steel combo bins were observed; the DVFA officials ordered repair or replacement.

35 (A) Several containers for edible product ready for use had not been adequately cleaned. The DVFA officials ordered them to be re-cleaned. (B) A large combo bin of edible product (trimmed fat) had been left uncovered and had been temporarily placed outside the establishment. The Veterinarian-In-Charge condemned the product.

41 The head inspector was routinely making only one rapid incision into each of some beef head lymph nodes and was not adequately observing the cut surfaces. The DVFA officials corrected this immediately.

76 The Veterinarian-In-Charge demonstrated a plan for his staff to conduct weekly verification of ten establishment activities. For all but one of the categories, verifications had not been performed during the majority of the eight weeks that had elapsed since the beginning of the year. During three of the eight weeks, none of these activities, including controls for fecal contamination and operational sanitation, had been performed.

83a The establishment management had not developed a statistical process control procedure for the evaluation of the results for *E. coli* testing; they were mistakenly using the method reserved for excision sampling. This was discussed in detail both during the establishment audit and at the country exit meeting. The DVFA officials notified the inspection personnel in all establishments certified as eligible for export to the U.S. within 48 hours of this finding in Est. 34.

83b Only one HACCP plan had been developed, which covered all products, some of which had different critical limits for temperature (for different customers) at shipping. DVFA agreed to ensure that separate HACCP plans would be developed for each product.

80 See above. The DVFA officials agreed with the FSIS Auditor that the establishment failed to meet the USDA requirements and voluntarily withdrew it from the list of establishments certified as eligible to export meat products to the United States, effective as of the start of operations on the day of the audit.

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U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/11/2002	ESTABLISHMENT NO. AND NAME 71 - Danish Crown Saeby		CITY Saeby
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. J.M.Ebbesen, I. Lahmann, N.R.Andersen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	
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Chlorination procedures	02 O	Product reconditioning		31 A	Label approvals
Back siphonage prevention	03 A	Product transportation		32 A	Special label claims
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM			Inspector monitoring
Sanitizers	05 A	Effective maintenance program		33 M	Processing schedules
Establishments separation	06 A	Preoperational sanitation		34 M	Processing equipment
Pest --no evidence	07 A	Operational sanitation		35 A	Processing records
Pest control program	08 A	Waste disposal		36 A	Empty can inspection
Pest control monitoring	09 A	2. DISEASE CONTROL			Filling procedures
Temperature control	10 A	Animal identification		37 A	Container closure exam
Lighting	11 A	Antemortem inspec. procedures		38 A	Interim container handling
Operations work space	12 A	Antemortem dispositions		39 A	Post-processing handling
Inspector work space	13 A	Humane Slaughter		40 A	Incubation procedures
Ventilation	14 A	Postmortem inspec. procedures		41 A	Process. defect actions -- plant
Facilities approval	15 A	Postmortem dispositions		42 A	Processing control -- inspection
Equipment approval	16 A	Condemned product control		43 A	5. COMPLIANCE/ECON. FRAUD CONTROL
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control		44 A	Export product identification
Over-product ceilings	17 A	Returned and rework product		45 A	Inspector verification
Over-product equipment	18 A	3. RESIDUE CONTROL			Export certificates
Product contact equipment	19 M	Residue program compliance		46 A	Single standard
Other product areas (inside)	20 A	Sampling procedures		47 A	Inspection supervision
Dry storage areas	21 A	Residue reporting procedures		48 A	Control of security items
Antemortem facilities	22 A	Approval of chemicals, etc.		49 A	Shipment security
Welfare facilities	23 A	Storage and use of chemicals		50 A	Species verification
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL			"Equal to" status
(c) PRODUCT PROTECTION & HANDLING		Pre-boning trim		51 A	Imports
Personal dress and habits	25 A	Boneless meat reinspection		52 A	SSOPs
Personal hygiene practices	26 A	Ingredients identification		53 A	HACCP/PR
Sanitary dressing procedures	27 A	Control of restricted ingredients		54 O	

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	COUNTRY Denmark		
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. J.M.Ebbesen, I. Lahmann, N.R.Andersen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable

## COMMENTS:

28 There was inadequate separation of containers for inedible product from containers for edible product. Also, floor-cleaning equipment was not routinely kept separate from edible product contact surfaces and aprons. The observed instances were corrected immediately, and the DVFA officials ordered immediate review of the program and implementation of improved controls.

33 Maintenance and cleaning of some over-product equipment had been neglected in several areas throughout the establishment. This was a partial repeat finding; similar deficiencies had been observed in other areas during the March-April FSIS audit, but those areas had received the appropriate attention. The management representatives gave assurances they would extend the improved maintenance procedures to the newly-identified problem areas.

19/34 A considerable number of product-contact surfaces were not adequately cleaned before the start of operations. Some of these were identified by the establishment representative, but more were identified by DVFA. All were cleaned before operations began.

83 Documentation of the Critical Limits for temperatures in the coolers and freezers had improved, but documentation of corrective actions when critical limits were exceeded was still in need of further improvement.

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U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/13/2002	ESTABLISHMENT NO. AND NAME 165 - Hjørring Frysehus		CITY Hjørring
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, I. Lahmann, I. Casper		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	
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Water potability records	01 A	Product handling and storage		30 A	Laboratory confirmation
Chlorination procedures	02 O	Product reconditioning		31 O	Label approvals
Back siphonage prevention	03 A	Product transportation		32 A	Special label claims
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM			Inspector monitoring
Sanitizers	05 A	Effective maintenance program		33 A	Processing schedules
Establishments separation	06 A	Preoperational sanitation		34 A	Processing equipment
Pest --no evidence	07 A	Operational sanitation		35 A	Processing records
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Pest control monitoring	09 A	2. DISEASE CONTROL			Filling procedures
Temperature control	10 A	Animal identification		37 O	Container closure exam
Lighting	11 A	Antemortem inspec. procedures		38 O	Interim container handling
Operations work space	12 A	Antemortem dispositions		39 O	Post-processing handling
Inspector work space	13 O	Humane Slaughter		40 O	Incubation procedures
Ventilation	14 A	Postmortem inspec. procedures		41 O	Process. defect actions -- plant
Facilities approval	15 A	Postmortem dispositions		42 O	Processing control -- inspection
Equipment approval	16 A	Condemned product control		43 A	5. COMPLIANCE/ECON. FRAUD CONTROL
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control		44 O	Export product identification
Over-product ceilings	17 A	Returned and rework product		45 O	Inspector verification
Over-product equipment	18 A	3. RESIDUE CONTROL			Export certificates
Product contact equipment	19 O	Residue program compliance		46 O	Single standard
Other product areas (inside)	20 O	Sampling procedures		47 O	Inspection supervision
Dry storage areas	21 A	Residue reporting procedures		48 O	Control of security items
Antemortem facilities	22 O	Approval of chemicals, etc.		49 A	Shipment security
Welfare facilities	23 A	Storage and use of chemicals		50 A	Species verification
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL			"Equal to" status
(c) PRODUCT PROTECTION & HANDLING		Pre-boning trim		51 O	Imports
Personal dress and habits	25 A	Boneless meat reinspection		52 O	SSOPs
Personal hygiene practices	26 A	Ingredients identification		53 O	HACCP/PR
Sanitary dressing procedures	27 O	Control of restricted ingredients		54 O	

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<b>FOREIGN PLANT REVIEW FORM</b> (reverse)	REVIEW DATE 2/13/2002	ESTABLISHMENT NO. AND NAME 165 - Hjørring Fryschus	CITY Hjørring
			COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, I. Lahmann, I. Casper		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable

COMMENTS:

No comments.

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/8/2002	ESTABLISHMENT NO. AND NAME 172 - Danfjoerd Frost		CITY Nykoebing
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, A.G. Hermann, C.C. Thorsen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	
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Water potability records	01 M	Product handling and storage		30 A	Laboratory confirmation
Chlorination procedures	02 O	Product reconditioning		31 O	Label approvals
Back siphonage prevention	03 O	Product transportation		32 A	Special label claims
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM			Inspector monitoring
Sanitizers	05 O	Effective maintenance program		33 A	Processing schedules
Establishments separation	06 A	Preoperational sanitation		34 A	Processing equipment
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Pest control monitoring	09 A	2. DISEASE CONTROL			Filling procedures
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Operations work space	12 A	Antemortem dispositions		39 O	Post-processing handling
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Dry storage areas	21 A	Residue reporting procedures		48 O	Control of security items
Antemortem facilities	22 O	Approval of chemicals, etc.		49 A	Shipment security
Welfare facilities	23 A	Storage and use of chemicals		50 A	Species verification
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL			"Equal to" status
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Sanitary dressing procedures	27 O	Control of restricted ingredients		54 O	

<b>FOREIGN PLANT REVIEW FORM</b> (reverse)	REVIEW DATE 2/8/2002	ESTABLISHMENT NO. AND NAME 172 - Danfjoerd Frost	CITY Nykoebing
			COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, A.G. Hernann, C.C. Thorsen	EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	

## COMMENTS:

01 In April 2001, a high total plate count (TPC) was reported in a routine water sample (440 reported; 200 acceptable). The establishment was informed by mail; system inspection and resampling were recommended. The water reticulation system was inspected and several valves replaced. The new sample was taken 22 days after the report was received. The TPC was now 150 (within tolerance). The results were reported within 48 hours.



U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/1/2002	ESTABLISHMENT NO. AND NAME 179 - Agri-Norcold		CITY Padborg
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, O.Nommensen, T. Sørensen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/Re-review <input type="checkbox"/> Unacceptable	
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			COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, O.Nommensen, T. Sørensen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable

## COMMENTS:

76 There were no internal reviews during the months of June, July, or October 2001.

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U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/4/2002	ESTABLISHMENT NO. AND NAME 190 - Aabenraa Frysehus		CITY Aabenraa
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. H. Pedersen, O. Nimmensen; U. Mikkelsen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input checked="" type="checkbox"/> Unacceptable	
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			COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. H. Pedersen, O. Nimmensen; U. Mikkelsen	EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input checked="" type="checkbox"/> Unacceptable	

## COMMENTS:

17/21/33 There were obvious holes in roughly a quarter of the ceiling tiles in the dry storage room. The management official expressed willing- ness to program repairs.

18/33 Maintenance and cleaning of some over-product equipment had been neglected (this was a repeat finding), hand- operated rail gate switches had not been adequately cleaned, and there were old meat scraps from previous days' production and buildups of dust on the machine used to seal the product into foil pouches. DVFA officials ordered prompt corrections. Heavy rust buildups were found on the drive wheels and under the main product contact platform on a band saw that was used for product for human consumption. The management representative stated that the saw was used only once a week and would be cleaned before use, in addition to its having been cleaned after its last use.

19/34/82 Product-contact equipment (cutting boards, the main exposed-product conveyor belt, and edible product containers) had not been adequately cleaned before the start of operations. DVFA officials ordered re-cleaning of the equipment. The establishment personnel did so, and informed DVFA that it had been completed. The DVFA officials found that the re-cleaning had also been inadequate. Several items of product-contact equipment, that had been specifically identified with product residues from previous days' production, and pointed out to the establishment management had not been re-cleaned at all. DVFA ordered a complete re-cleaning of the entire area and daily monitoring by DVFA of the pre-operational sanitation before production would be allowed to begin, until further notice. Documentation by the Veterinarian-In- Charge indicated that the establishment's pre-operational sanitation inspections were inadequate approximately every second time he conducted his (bi-weekly) independent pre-operational sanitation checks.

30 Obvious contamination of product with ingesta was found in the cooler on product that had, according to establishment documentation, passed inspection by the responsible management official. DVFA ordered complete inspection of all product in the cooler before it would be allowed to be used. Grossly excessive, falling snow was present in one of the two freezers entered during the audit. Many cartons of product were thickly covered with snow. No corrective actions were taken.

33/50 Cleaning compounds were stored on a very rusty metal shelf in a storage room that opened directly into the main boning room. No corrective actions were taken.

76 There were no internal reviews during the months of June, July, or October 2001.

82 Documentation of corrective actions was, at times, inadequate; preventive measures were not included in the corrective action documentation. Documentation by the Veterinarian-In-Charge indicated that the establishment's pre-operational sanitation inspections were inadequate approximately every second time he conducted his (bi-weekly) independent pre-operational sanitation checks. DVFA officials gave assurances they would enforce corrective action.

83a The establishment management was not documenting the monitoring of the CCP for absence of visible contamination of product at receiving. (Obvious contamination with ingesta was observed on a beef quarter in the cooler, that had, according to the documentation, been inspected by the responsible establishment official and passed.) DVFA ordered immediate correction.

83b The establishment had not developed verification procedures to ensure that the HACCP plan was working as intended to prevent product contamination (see item 30). This was a repeat finding. DVFA ordered prompt correction.

83c The establishment official performing the pre-shipment document review was the same person who monitored the critical limits.

80 The DVFA officials present during the audit determined that the establishment did not meet U.S. requirements and removed it from the list of establishments eligible for U.S. export, as of the start of operations on the day of the audit. The FSIS auditor was in complete agreement with this decision.

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/13/2002	ESTABLISHMENT NO. AND NAME 191 - Claus Sørensen A/S, Skagen		CITY Skagen
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen & I. Lahmann; Mr. T.R. Sørensen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/Re-review <input type="checkbox"/> Unacceptable	
CODES (Give an appropriate code for each review item listed below) A = Acceptable    M = Marginally Acceptable    U = Unacceptable    N = Not Reviewed    O = Does not apply					
1. CONTAMINATION CONTROL		Cross contamination prevention	28 O	Formulations	55 O
(a) BASIC ESTABLISHMENT FACILITIES		Equipment Sanitizing	29 O	Packaging materials	56 A
Water potability records	01 A	Product handling and storage	30 A	Laboratory confirmation	57 O
Chlorination procedures	02 O	Product reconditioning	31 O	Label approvals	58 O
Back siphonage prevention	03 A	Product transportation	32 A	Special label claims	59 O
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM		Inspector monitoring	60 O
Sanitizers	05 A	Effective maintenance program	33 A	Processing schedules	61 O
Establishments separation	06 A	Preoperational sanitation	34 A	Processing equipment	62 O
Pest --no evidence	07 A	Operational sanitation	35 A	Processing records	63 O
Pest control program	08 A	Waste disposal	36 A	Empty can inspection	64 O
Pest control monitoring	09 A	2. DISEASE CONTROL		Filling procedures	65 O
Temperature control	10 A	Animal identification	37 O	Container closure exam	66 O
Lighting	11 A	Antemortem inspec. procedures	38 O	Interim container handling	67 O
Operations work space	12 A	Antemortem dispositions	39 O	Post-processing handling	68 O
Inspector work space	13 O	Humane Slaughter	40 O	Incubation procedures	69 O
Ventilation	14 A	Postmortem inspec. procedures	41 O	Process. defect actions -- plant	70 O
Facilities approval	15 A	Postmortem dispositions	42 O	Processing control -- inspection	71 O
Equipment approval	16 A	Condemned product control	43 O	5. COMPLIANCE/ECON. FRAUD CONTROL	
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control	44 O	Export product identification	72 A
Over-product ceilings	17 A	Returned and rework product	45 O	Inspector verification	73 A
Over-product equipment	18 A	3. RESIDUE CONTROL		Export certificates	74 A
Product contact equipment	19 O	Residue program compliance	46 O	Single standard	75 A
Other product areas (inside)	20 O	Sampling procedures	47 O	Inspection supervision	76 M
Dry storage areas	21 A	Residue reporting procedures	48 O	Control of security items	77 A
Antemortem facilities	22 O	Approval of chemicals, etc.	49 A	Shipment security	78 A
Welfare facilities	23 A	Storage and use of chemicals	50 A	Species verification	79 O
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL		"Equal to" status	80 A
(c) PRODUCT PROTECTION & HANDLING		Pre-boning trim	51 O	Imports	81 A
Personal dress and habits	25 A	Boneless meat reinspection	52 O	SSOPs	82 A
Personal hygiene practices	26 A	Ingredients identification	53 O	HACCP/PR	83 O
Sanitary dressing procedures	27 O	Control of restricted ingredients	54 O		

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FOREIGN PLANT REVIEW FORM (reverse)	REVIEW DATE 2/13/2002	ESTABLISHMENT NO. AND NAME 191 - Claus Sørensen A/S, Skagen	CITY Skagen
			COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs.J.M.Ebbesen & I.Lahmann;Mr.T.R.Sørensen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable

## COMMENTS:

76 There had been no supervisory internal reveiw in May 2001, reportedly due to a misunderstanding between the two regional reviewers.

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/19/2002	ESTABLISHMENT NO. AND NAME 205 - Steff Houlberg Ebeltoft A.M.B.A.		CITY Ebeltoft
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. Henning Petersen, Knud Fallesen, R. Hansen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	
CODES (Give an appropriate code for each review item listed below) A = Acceptable    M = Marginally Acceptable    U = Unacceptable    N = Not Reviewed    O = Does not apply					
1. CONTAMINATION CONTROL		Cross contamination prevention	28 A	Formulations	55 A
(a) BASIC ESTABLISHMENT FACILITIES		Equipment Sanitizing	29 A	Packaging materials	56 A
Water potability records	01 A	Product handling and storage	30 A	Laboratory confirmation	57 A
Chlorination procedures	02 A	Product reconditioning	31 A	Label approvals	58 O
Back siphonage prevention	03 A	Product transportation	32 O	Special label claims	59 O
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM		Inspector monitoring	60 A
Sanitizers	05 A	Effective maintenance program	33 M	Processing schedules	61 A
Establishments separation	06 A	Preoperational sanitation	34 A	Processing equipment	62 A
Pest --no evidence	07 A	Operational sanitation	35 A	Processing records	63 A
Pest control program	08 A	Waste disposal	36 A	Empty can inspection	64 O
Pest control monitoring	09 A	2. DISEASE CONTROL		Filling procedures	65 O
Temperature control	10 A	Animal identification	37 O	Container closure exam	66 O
Lighting	11 A	Antemortem inspec. procedures	38 O	Interim container handling	67 A
Operations work space	12 A	Antemortem dispositions	39 O	Post-processing handling	68 A
Inspector work space	13 O	Humane Slaughter	40 O	Incubation procedures	69 O
Ventilation	14 A	Postmortem inspec. procedures	41 O	Process. defect actions -- plant	70 A
Facilities approval	15 A	Postmortem dispositions	42 O	Processing control -- inspection	71 A
Equipment approval	16 A	Condemned product control	43 A	5. COMPLIANCE/ECON. FRAUD CONTROL	
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control	44 A	Export product identification	72 A
Over-product ceilings	17 A	Returned and rework product	45 A	Inspector verification	73 A
Over-product equipment	18 M	3. RESIDUE CONTROL		Export certificates	74 A
Product contact equipment	19 M	Residue program compliance	46 O	Single standard	75 A
Other product areas (inside)	20 A	Sampling procedures	47 O	Inspection supervision	76 A
Dry storage areas	21 A	Residue reporting procedures	48 O	Control of security items	77 A
Antemortem facilities	22 O	Approval of chemicals, etc.	49 A	Shipment security	78 A
Welfare facilities	23 A	Storage and use of chemicals	50 A	Species verification	79 M
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL		"Equal to" status	80 A
(c) PRODUCT PROTECTION & HANDLING		Pre-boning trim	51 A	Imports	81 A
Personal dress and habits	25 A	Boneless meat reinspection	52 A	SSOPs	82 A
Personal hygiene practices	26 A	Ingredients identification	53 A	HACCP/PR	83 M
Sanitary dressing procedures	27 O	Control of restricted ingredients	54 O		

<b>FOREIGN PLANT REVIEW FORM</b> (reverse)	REVIEW DATE 2/19/2002	ESTABLISHMENT NO. AND NAME 205 - Steff Houlberg Ebeltoft A.M.B.A.	CITY Ebeltoft COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. Henning Petersen, Knud Fallesen, R. Hansen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable

## COMMENTS:

18/33 Maintenance and cleaning of over-product structures (rail gate switch handles and rail structures) had been neglected in one cooler for hams and shoulders. The gate switches were cleaned immediately, and the management representative scheduled prompt correction for the other structures.

19 Large plastic containers for edible product were routinely placed directly on the floor, and a number of these containers, that had not been adequately cleaned, were stacked and ready for use. The DVFA officials ordered corrective actions and agreed to ensure continued resolution of the problem. Also, several cracked stainless steel combo bins were in use. The management official ordered them taken out of production for repair.

79 No species verification was performed on product from this establishment, although both pork and beef were processed. The DVFA officials gave assurances this would be corrected promptly.

83a Pre-Shipment Document Reviews were not implemented until January 11, 2002. No product was exported directly to the U.S. from this establishment, but products were routinely sent to a sister establishment for U.S.-eligible further production. Note: prior to the implementation of PSDRs, monitoring of critical limits had been reliably performed and documented.

83b HACCP plans had individual CCPs with multiple critical limits. The management agreed to correct this promptly.



U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 12/2/2002	ESTABLISHMENT NO. AND NAME 286 - EdiDan (Edible Danish Proteins)	CITY Aabybro	
FOREIGN PLANT REVIEW FORM				COUNTRY Denmark	
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, I. Lahmann, L. Mogstad		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	
CODES (Give an appropriate code for each review item listed below) A = Acceptable    M = Marginally Acceptable    U = Unacceptable    N = Not Reviewed    O = Does not apply					
1. CONTAMINATION CONTROL		Cross contamination prevention	28 A	Formulations	
(a) BASIC ESTABLISHMENT FACILITIES		Equipment Sanitizing	29 A	Packaging materials	
Water potability records	01 A	Product handling and storage	30 A	Laboratory confirmation	
Chlorination procedures	02 O	Product reconditioning	31 O	Label approvals	
Back siphonage prevention	03 A	Product transportation	32 O	Special label claims	
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM		Inspector monitoring	
Sanitizers	05 O	Effective maintenance program	33 A	Processing schedules	
Establishments separation	06 A	Preoperational sanitation	34 A	Processing equipment	
Pest --no evidence	07 A	Operational sanitation	35 A	Processing records	
Pest control program	08 A	Waste disposal	36 A	Empty can inspection	
Pest control monitoring	09 A	2. DISEASE CONTROL		Filling procedures	
Temperature control	10 A	Animal identification	37 O	Container closure exam	
Lighting	11 A	Antemortem inspec. procedures	38 O	Interim container handling	
Operations work space	12 A	Antemortem dispositions	39 O	Post-processing handling	
Inspector work space	13 O	Humane Slaughter	40 O	Incubation procedures	
Ventilation	14 A	Postmortem inspec. procedures	41 O	Process. defect actions -- plant	
Facilities approval	15 A	Postmortem dispositions	42 O	Processing control -- inspection	
Equipment approval	16 A	Condemned product control	43 A	5. COMPLIANCE/ECON. FRAUD CONTROL	
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control	44 O	Export product identification	72 A
Over-product ceilings	17 A	Returned and rework product	45 O	Inspector verification	73 A
Over-product equipment	18 A	3. RESIDUE CONTROL		Export certificates	74 A
Product contact equipment	19 A	Residue program compliance	46 O	Single standard	75 A
Other product areas (inside)	20 A	Sampling procedures	47 O	Inspection supervision	76 A
Dry storage areas	21 A	Residue reporting procedures	48 O	Control of security items	77 A
Antemortem facilities	22 O	Approval of chemicals, etc.	49 A	Shipment security	78 A
Welfare facilities	23 A	Storage and use of chemicals	50 A	Species verification	79 O
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL		"Equal to" status	80 A
(c) PRODUCT PROTECTION & HANDLING		Pre-boning trim	51 O	Imports	81 A
Personal dress and habits	25 A	Boneless meat reinspection	52 O	SSOPs	82 A
Personal hygiene practices	26 A	Ingredients identification	53 A	HACCP/PR	83 A
Sanitary dressing procedures	27 O	Control of restricted ingredients	54 O		

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FOREIGN PLANT REVIEW FORM (reverse)	REVIEW DATE 12/2/2002	ESTABLISHMENT NO. AND NAME 286 - EdiDan (Edible Danish Proteins)	CITY Aabybro
			COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. J.M. Ebbesen, I. Lahmann, L. Mogstad		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable

## COMMENTS:

No comments.

U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE 2/5/2002	ESTABLISHMENT NO. AND NAME 311 - Danish Crown Skaerbaek		CITY Skaerbaek
FOREIGN PLANT REVIEW FORM					COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. H. Pedersen, O. Nimmensen, J. Christensen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	
CODES (Give an appropriate code for each review item listed below) A = Acceptable    M = Marginally Acceptable    U = Unacceptable    N = Not Reviewed    O = Does not apply					
1. CONTAMINATION CONTROL		Cross contamination prevention		28 A	Formulations
(a) BASIC ESTABLISHMENT FACILITIES		Equipment Sanitizing		29 A	Packaging materials
Water potability records	01 A	Product handling and storage		30 M	Laboratory confirmation
Chlorination procedures	02 O	Product reconditioning		31 A	Label approvals
Back siphonage prevention	03 A	Product transportation		32 A	Special label claims
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM			Inspector monitoring
Sanitizers	05 A	Effective maintenance program		33 A	Processing schedules
Establishments separation	06 A	Preoperational sanitation		34 M	Processing equipment
Pest --no evidence	07 A	Operational sanitation		35 A	Processing records
Pest control program	08 A	Waste disposal		36 A	Empty can inspection
Pest control monitoring	09 A	2. DISEASE CONTROL			Filling procedures
Temperature control	10 A	Animal identification		37 A	Container closure exam
Lighting	11 M	Antemortem inspec. procedures		38 A	Interim container handling
Operations work space	12 A	Antemortem dispositions		39 A	Post-processing handling
Inspector work space	13 A	Humane Slaughter		40 A	Incubation procedures
Ventilation	14 A	Postmortem inspec. procedures		41 A	Process. defect actions -- plant
Facilities approval	15 A	Postmortem dispositions		42 A	Processing control -- inspection
Equipment approval	16 A	Condemned product control		43 A	5. COMPLIANCE/ECON. FRAUD CONTROL
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control		44 A	Export product identification
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Over-product equipment	18 M	3. RESIDUE CONTROL			Export certificates
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Other product areas (inside)	20 A	Sampling procedures		47 A	Inspection supervision
Dry storage areas	21 A	Residue reporting procedures		48 A	Control of security items
Antemortem facilities	22 A	Approval of chemicals, etc.		49 A	Shipment security
Welfare facilities	23 A	Storage and use of chemicals		50 M	Species verification
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL			"Equal to" status
(c) PRODUCT PROTECTION & HANDLING		Pre-boning trim		51 A	Imports
Personal dress and habits	25 A	Boneless meat reinspection		52 O	SSOPs
Personal hygiene practices	26 A	Ingredients identification		53 O	HACCP/PR
Sanitary dressing procedures	27 A	Control of restricted ingredients		54 O	

FOREIGN PLANT REVIEW FORM (reverse)	REVIEW DATE 2/5/2002	ESTABLISHMENT NO. AND NAME 311 - Danish Crown Skaerbaek	CITY Skaerbaek
	COUNTRY Denmark		
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. H. Pedersen, O. Nimmensen, J. Christensen	EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	

## COMMENTS:

11 Light was inadequate at two postmortem inspection areas: an intensity of 10 foot-candles (fc) was measured at the surfaces of mandibular lymph nodes and 30 fc in abdominal cavities at the retained rail. DVFA officials ordered prompt correction.

18/30 Condensation was observed in several areas of carcass coolers, directly above exposed product, before the start of cutting operations. DVFA ordered corrective actions immediately. Several trees of pork shoulders that had been stored under the worst problem area were ordered to be identified for cooking only.

19/34 Numerous items of product-contact equipment, including cutting boards, hoist switches, and line control switches, had not been adequately cleaned before the start of operations. DVFA officials identified most of the overlooked items; the FSIS Auditor identified several others. All were ordered to be thoroughly cleaned before work was allowed to start, reinspected, and passed. All identified items were re-cleaned properly except one hoist switch, one hand saw, and one electricity control. These were corrected immediately when brought to the establishment's content.

50 Some chemicals (including hand soap) were stored under insanitary conditions. DVFA officials ordered prompt correction.

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U.S. DEPARTMENT OF AGRICULTURE FOOD SAFETY AND INSPECTION SERVICE INTERNATIONAL PROGRAMS		REVIEW DATE	ESTABLISHMENT NO. AND NAME		CITY
FOREIGN PLANT REVIEW FORM		2/15/2002	469 - Danish Crown Hadsund		Hadsund
NAME OF REVIEWER Dr. Gary D. Bolstad		NAME OF FOREIGN OFFICIAL Drs. J.M.Ebbesen, I.Lahrmann, R.S. Petersen		COUNTRY Denmark	
				EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable	
CODES (Give an appropriate code for each review item listed below)					
A = Acceptable    M = Marginally Acceptable    U = Unacceptable    N = Not Reviewed    O = Does not apply					
1. CONTAMINATION CONTROL		Cross contamination prevention	28 A	Formulations	55 A
(a) BASIC ESTABLISHMENT FACILITIES		Equipment Sanitizing	29 A	Packaging materials	56 A
Water potability records	01 A	Product handling and storage	30 A	Laboratory confirmation	57 A
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Back siphonage prevention	03 A	Product transportation	32 O	Special label claims	59 O
Hand washing facilities	04 A	(d) ESTABLISHMENT SANITATION PROGRAM		Inspector monitoring	60 A
Sanitizers	05 A	Effective maintenance program	33 M	Processing schedules	61 A
Establishments separation	06 A	Preoperational sanitation	34 A	Processing equipment	62 A
Pest --no evidence	07 A	Operational sanitation	35 A	Processing records	63 A
Pest control program	08 A	Waste disposal	36 A	Empty can inspection	64 O
Pest control monitoring	09 A	2. DISEASE CONTROL		Filling procedures	65 O
Temperature control	10 A	Animal identification	37 O	Container closure exam	66 O
Lighting	11 A	Antemortem inspec. procedures	38 O	Interim container handling	67 O
Operations work space	12 A	Antemortem dispositions	39 O	Post-processing handling	68 A
Inspector work space	13 A	Humane Slaughter	40 O	Incubation procedures	69 O
Ventilation	14 A	Postmortem inspec. procedures	41 O	Process. defect actions -- plant	70 A
Facilities approval	15 A	Postmortem dispositions	42 O	Processing control -- inspection	71 A
Equipment approval	16 A	Condemned product control	43 A	5. COMPLIANCE/ECON. FRAUD CONTROL	
(b) CONDITION OF FACILITIES EQUIPMENT		Restricted product control	44 O	Export product identification	72 A
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Welfare facilities	23 A	Storage and use of chemicals	50 A	Species verification	79 O
Outside premises	24 A	4. PROCESSED PRODUCT CONTROL		"Equal to" status	80 A
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Personal hygiene practices	26 A	Ingredients identification	53 A	HACCP/PR	83 A
Sanitary dressing procedures	27 O	Control of restricted ingredients	54 O		

FOREIGN PLANT REVIEW FORM (reverse)	REVIEW DATE 2/15/2002	ESTABLISHMENT NO. AND NAME 469 - Danish Crown Hadsund	CITY Hadsund
			COUNTRY Denmark
NAME OF REVIEWER Dr. Gary D. Bolstad	NAME OF FOREIGN OFFICIAL Drs. J.M.Ebbesen, I.Lahrmann, R.S. Petersen		EVALUATION <input type="checkbox"/> Acceptable <input type="checkbox"/> Acceptable/ Re-review <input type="checkbox"/> Unacceptable

## COMMENTS:

18/33 Maintenance and cleaning of some over-product equipment had been neglected in numerous areas throughout the establishment. The establishment management official gave assurances that they all would receive prompt attention.

76 There were no internal reviews for the months of July, August, or September 2001, although there was supporting documentation that the supervisory reviewer had paid several visits to the establishment during each of those months.